

FIG.24

*"rows"*

*"columns"*

*"further division" (columns)*

*"first division" (rows)*

*"further division" (rows)*

*"first division" (columns)*

HY →	HT ↓	HY2 →	HY1 →	MACHINING SPEED			
				EDGE THICKNESS		THICK THIN	
HT1 →	CIRCUMFERENTIAL SURFACE ROUGH MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	03	04
HT2 →	CIRCUMFERENTIAL SURFACE FINISHING MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	05	05	05	05
HT3 →	GROOVE MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	04	04
HT4 →	CHAMFERING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	04	04